

## Work Order ID 68053



Tuesday, April 05, 2011 3:15:35 PM

Item ID: D4306-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, RH

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: 

Date: 11/0

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4306	C								

100

Weld per dwg A/R S.S. rod Batch: 115928 0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube 52"

2- Bend tube with manuel pipe bender as per DT9567

\*\*\* Make line at 10.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*

3- Trim access tube material to finish size and cut notch as per dwg D4306-4

4- Drill and chamfer holes as per dwg D4306-4 using DT9710

5- weld bushing as per dwg D4306

6- grind welds flush

Pl 11.04.08 1x

SAD 11-04-06

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Sulovog

40

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 68053**

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Page 2

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Subtotal



Quality Control

130

Identify as per dwg &amp; Stock Location

0.00



Packaging

Memo

0.00

B/C

Pl 11-04-08

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/04/11

Quality Control

MF

11-04-08

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# Picklist Print

Tuesday, April 05, 2011 3:15:42 PM

Page 1

Work Order ID: 68053



Parent Item: D4306-044



Parent Item Name: Rib Assembly, RH

Start Date: 4/5/2011

Required Date: 4/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC  
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1 Manufactured No

100

Each

306.0000

4 4



Bushing



Pl 11.04.08

Location

Loc Qty

Loc Code

WA005

306

66489

106

66870

200

4

M304TS0.750W.049

Purchased

No

100

f

37.9252

4.166

4.385263



SFA 11-04-07

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018

37.9252

117029

37.9252

M 117337

4.3853

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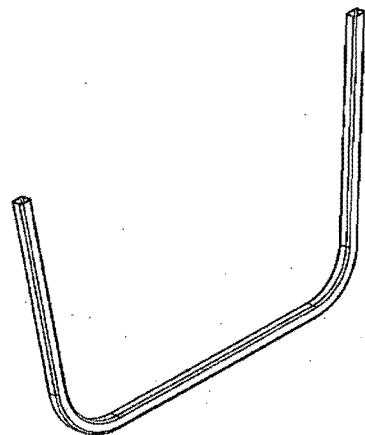
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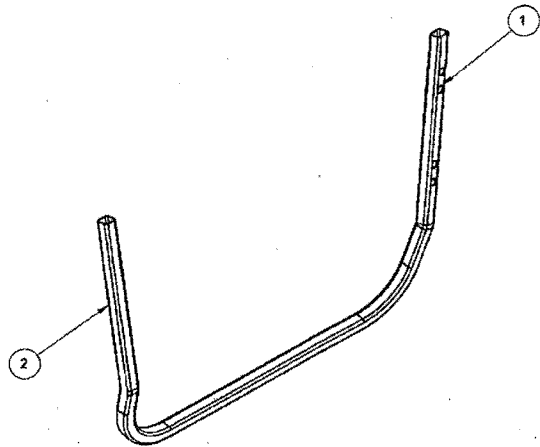
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 WITHOUT NOTICE  
 WORK ORDER  
 NO. 68053  
R11-04-5

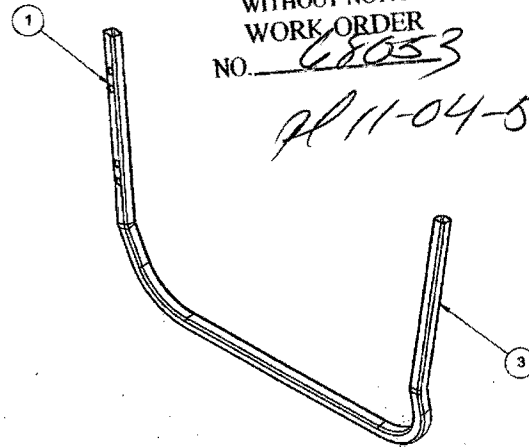
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	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



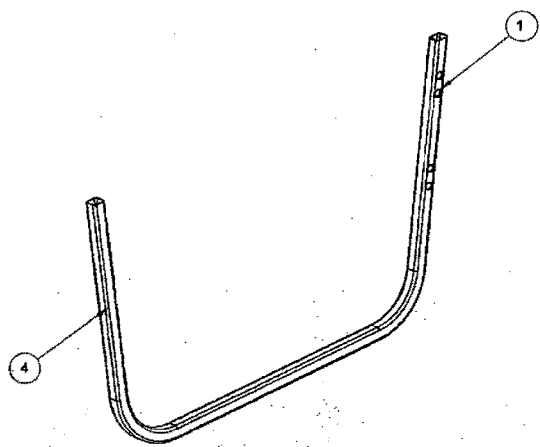
**D4306-1 RIB**



**D4306-043 RIB ASSY, LH**



**D4306-044 RIB ASSY, RH**



**D4306-045 RIB ASSY**

**RELEASED**  
 2011-03-11

REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4/-6); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.50" REF DIM ON D4306-043044 (B6-3, B3-5)		SC	11.02.09
B D4306-043, D4306-044, D4306-045 ADDED		SC	10.12.17
A NEW ISSUE		CP	10.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAYKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4306	SHEET 1 OF 8
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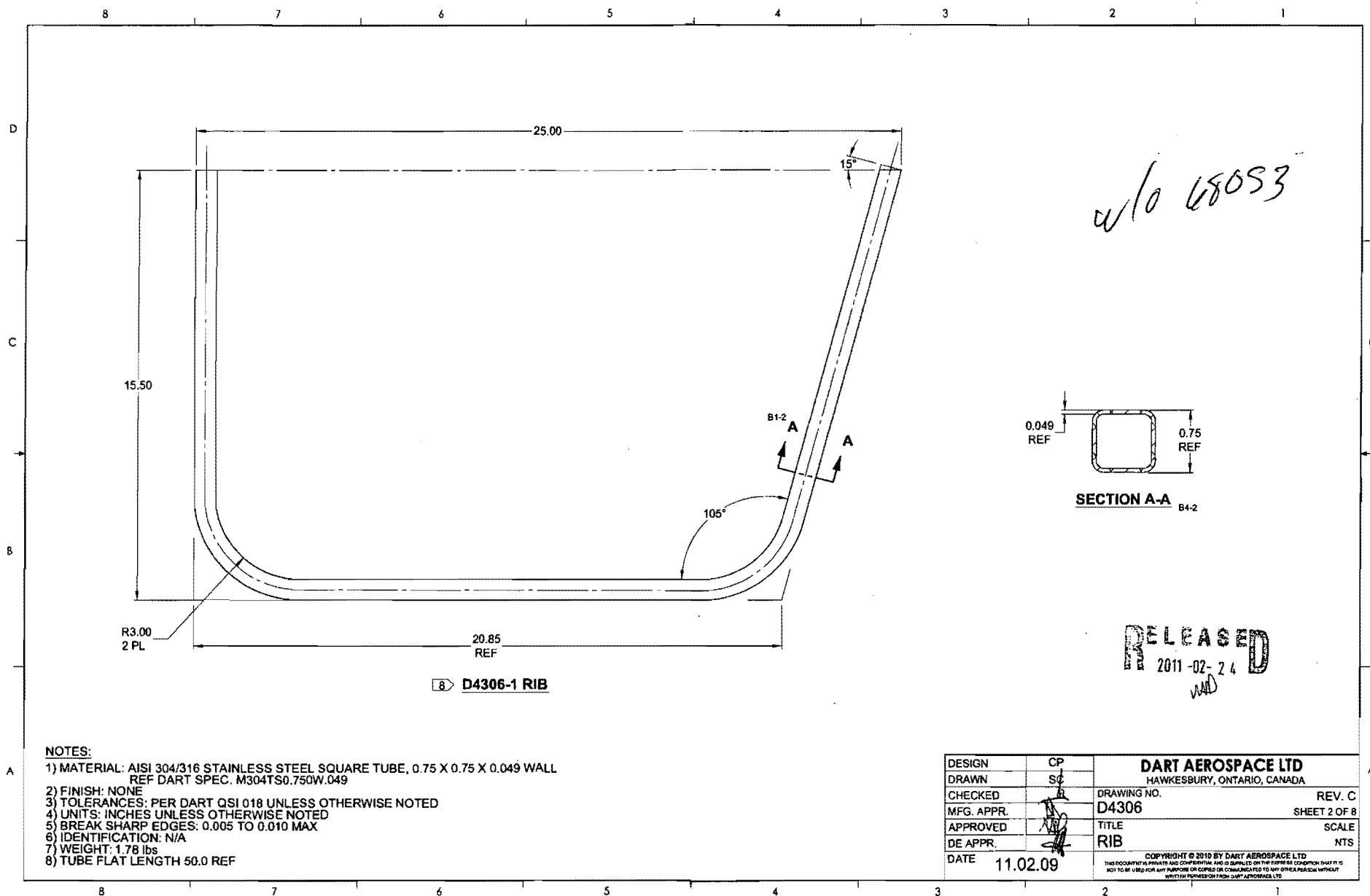
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**NOTE:** Date & initial all entries





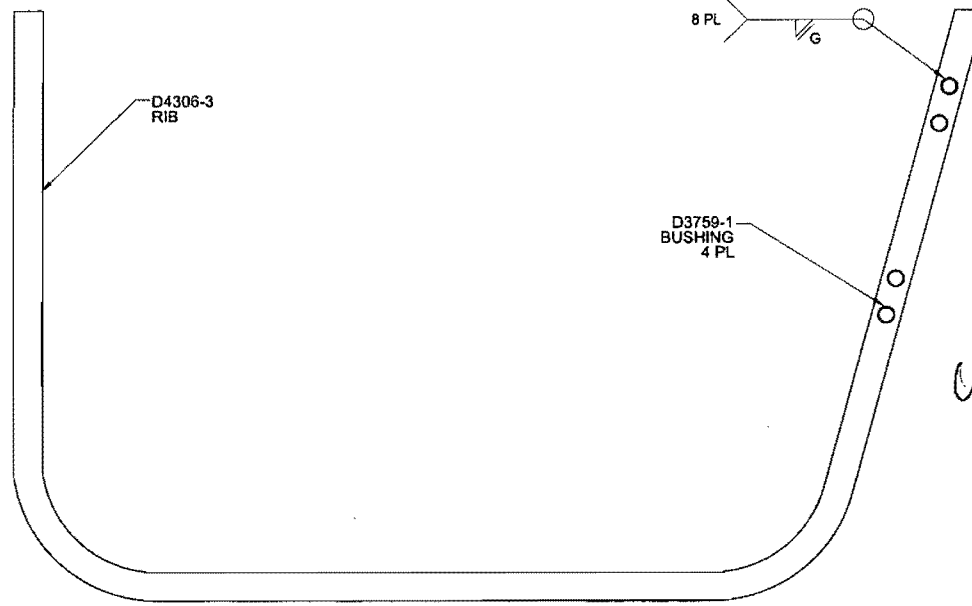
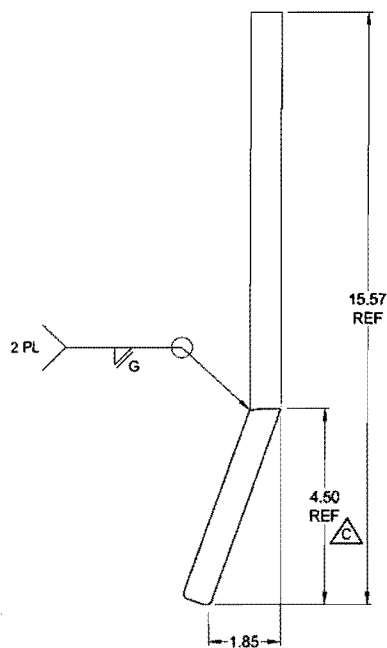
**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
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**NOTE:** Date & initial all entries



*into cross*

# **D4306-043 RIB ASSY, LH**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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2011-02-24  
*MB*

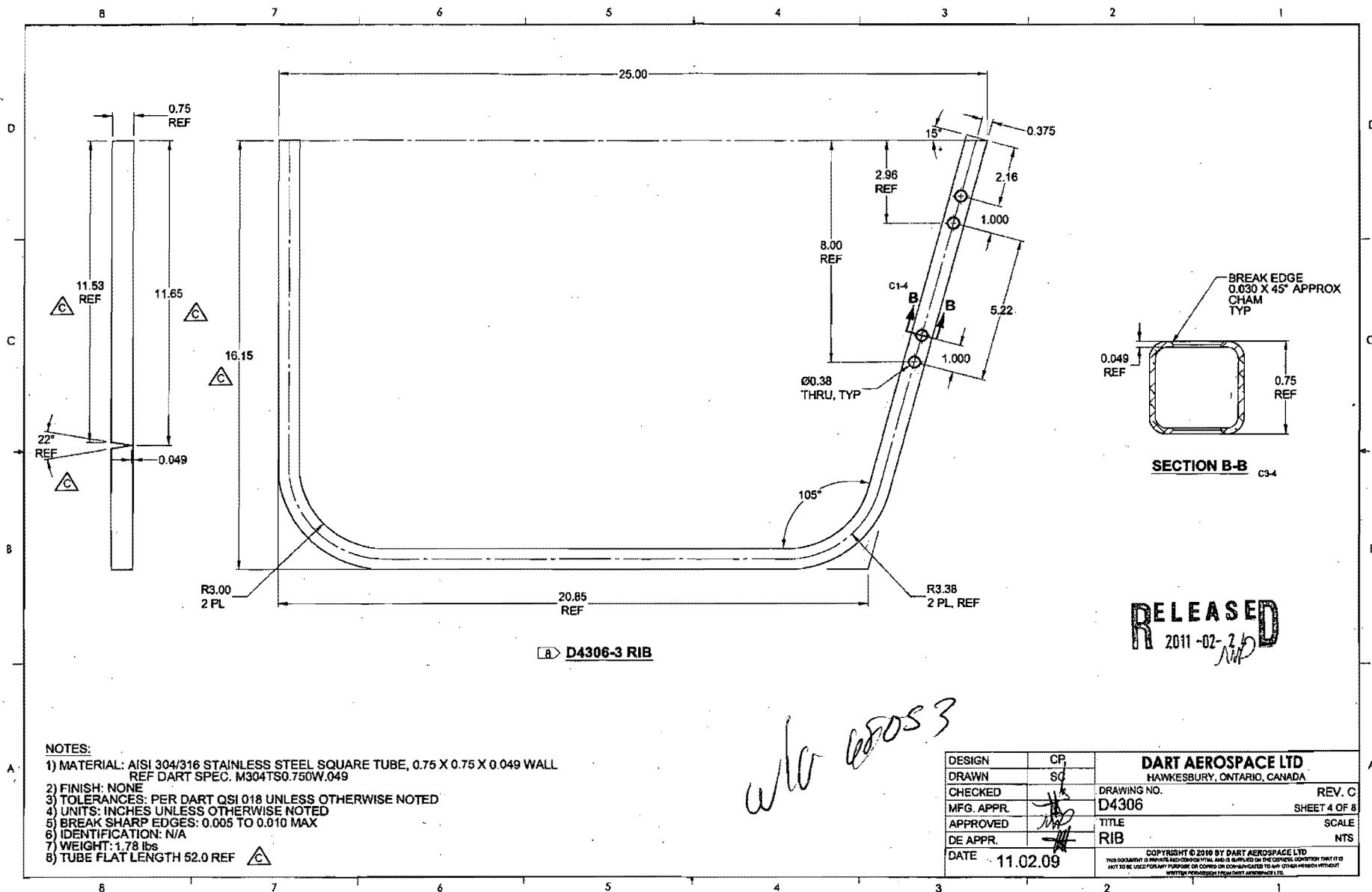
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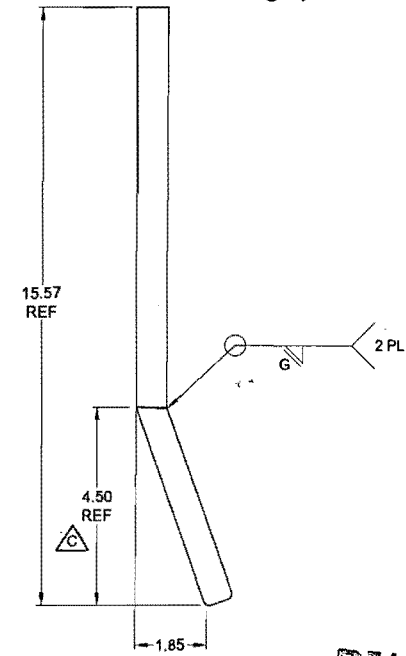
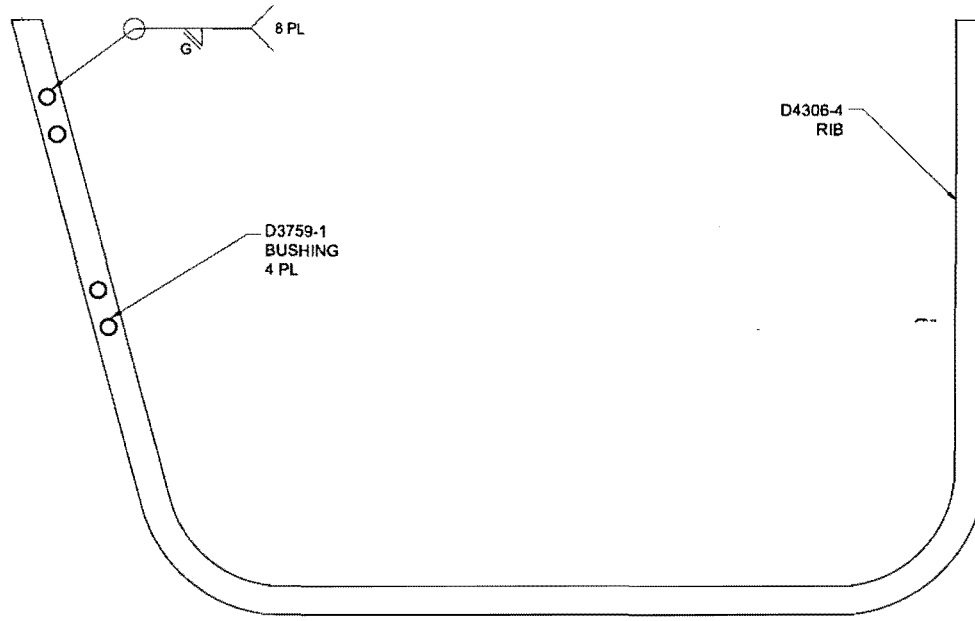
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**NOTE:** Date & initial all entries

W/O 48053



**D4306-044 RIB ASSY, RH**

**RELEASED**  
2011-02-24

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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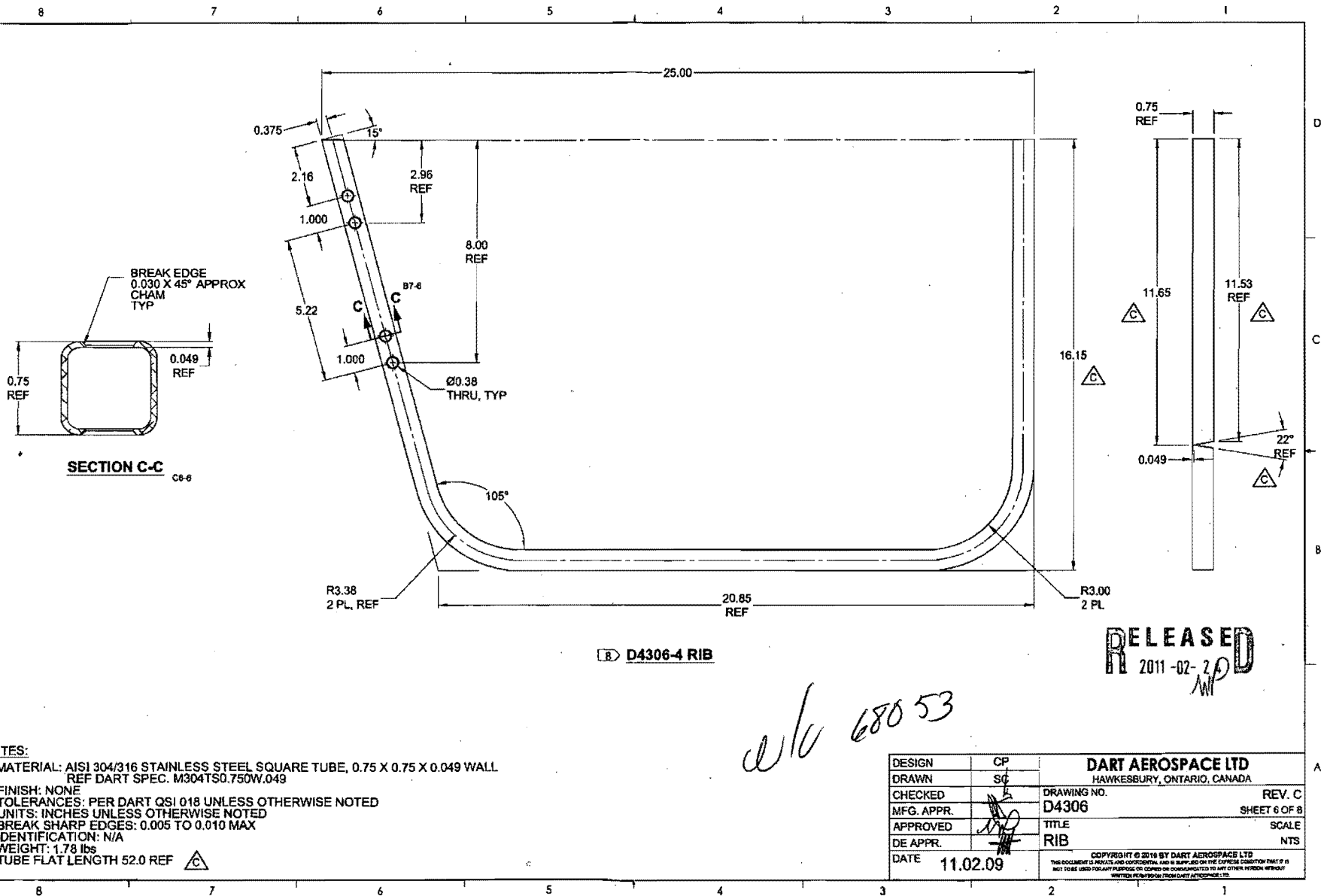
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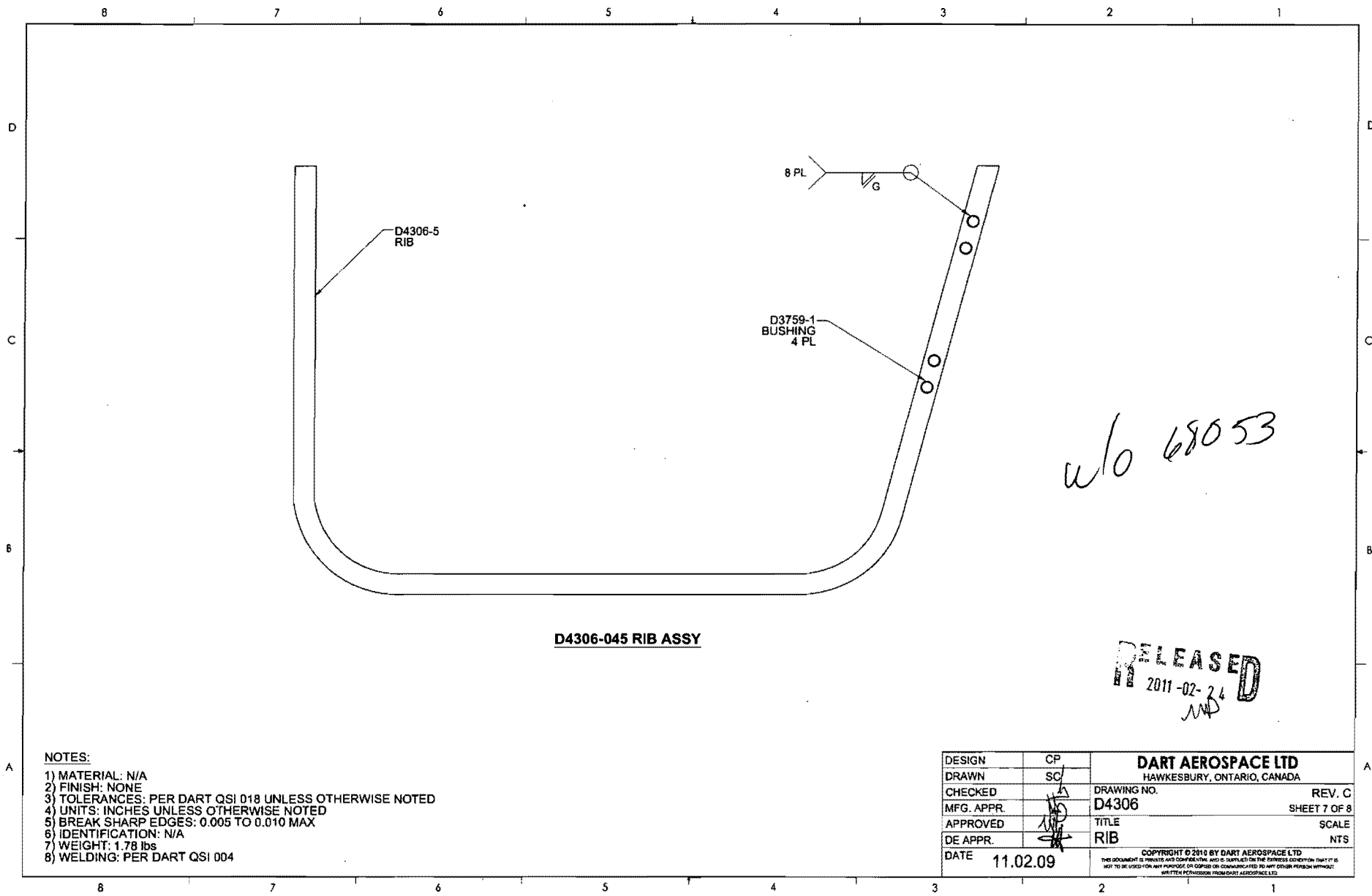
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**NOTE:** Date & initial all entries



w/o 68053

**D4306-045 RIB ASSY**

**RELEASED**  
2011-02-24  
MB

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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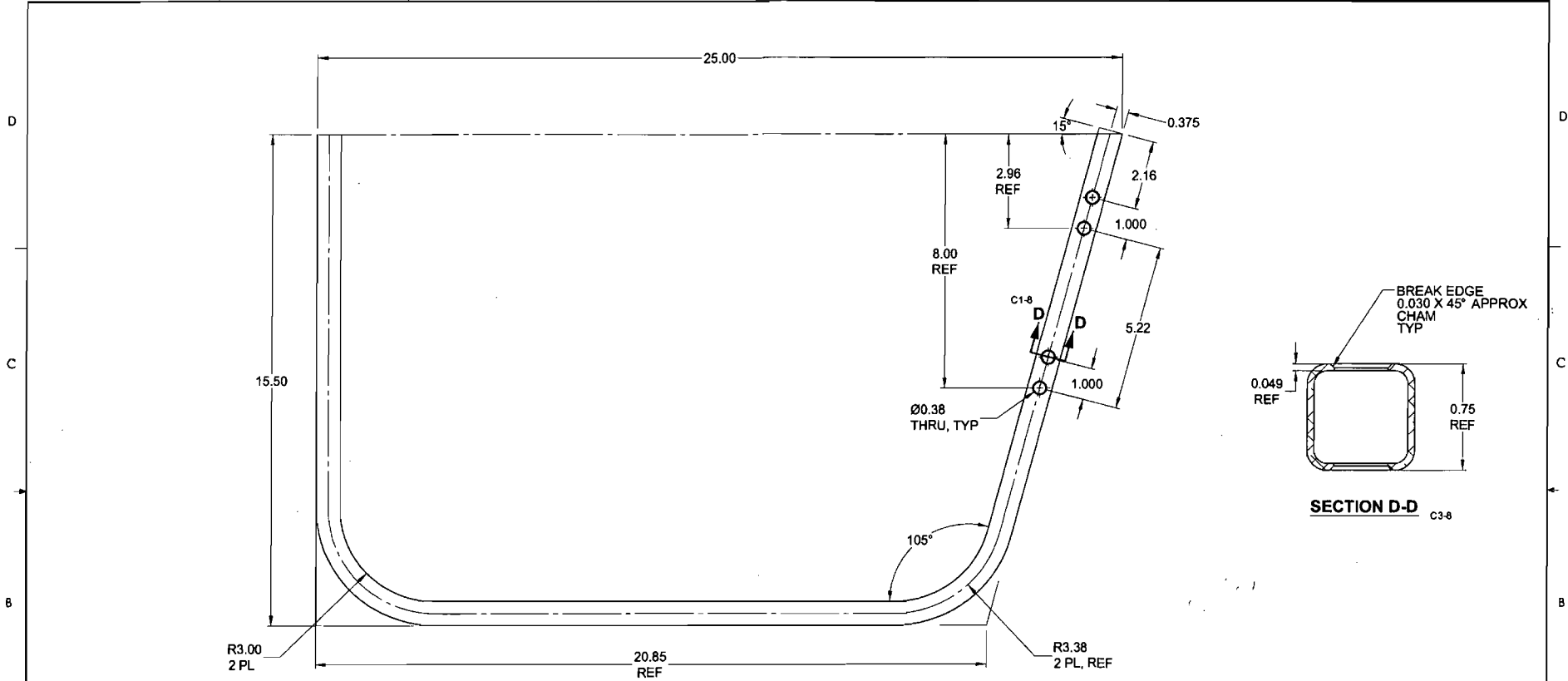
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



8 D4306-5 RIB

u 6 680 53

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2011-02-24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

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8 7 6 5 4 3 2 1

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